

Work Order ID 75821

75821

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October-31-11 12:44:31 PM

Item ID: D3529-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bearpaw
 Start Date: 31/10/2011 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 14/11/2011 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 11/10/31 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3529	Rev A								

110 0.00
110 FLOW WATER JET
 Waterjet Memo 0.00
 FLOW CNC Waterjet CUT BLANK AS PER FILE D3529-1BLANK
 11-11-31
 (4)

120 0.00
120 HAAS CNC VERTICAL MACHINING #1
 HAAS 1 Memo 0.00
 HAAS CNC vertical machine #1 1-Inspect material for defects or damage prior to machining2-Machine as per Folio FA645 and Dwg D35293-Deburr
 JL 11-11-28
 (4)

130 0.00
130 QC2- Inspect parts off machine FAI/FAIB
 QC Memo 0.00
 Quality Control
 JL 11-11-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 *140* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	<i>amf 11/11/28</i>			<u>4</u>	<u>0</u>		
150 *150* Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo <i>PPD 75820</i>	0.00 0.00							<i>11/11/29 (4)</i>
160 *160* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							<i>11/11/29</i> <i>amf 11-11-29</i>

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Picklist Print

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Work Order ID: 75821

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Parent Item: D3529-1

D3529-1

Parent Item Name: Bearpaw

Start Date: 31/10/2011

Required Date: 14/11/2011

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP Rev:A New Issue 06-06-28 JLM

IPP Rev:B New Manufacturing Method 08-11-27 Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MUHMWB10

Purchased

No

100

sf

678.0000

1.265

5.326316

MUHMWB10

811-11-1

UHMW 1" Black

Location

Loc Qty

Loc Code

MAT018

618.2

117321

74.6

117738

124.3

117819

99.3

119145

320

ST

59.8

118814

59.8

118814

(24)

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DART AEROSPACE LTD		Work Order:	75821
Description: Bearpaw		Part Number:	D3529-1
Inspection Dwg: D3529 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	5.50	+/-0.030	5.500	✓		Vern JLG	
B	0.07 x 45°	+/-0.030 x 0.5°	0.05 x 45°	✓			
C	R0.25	+/-0.030	0.25	✓			
D	0.250	+/-0.010	0.249	✓			
E	0.625	+/-0.010	0.624	✓			
F	0.950	+/-0.010	0.950	✓			
G	1.63	+/-0.030	1.620	✓			
H	12.14	+/-0.030	12.14	✓			
I							
J	5.70	+/-0.030	5.70	✓			
K	0.375	+/-0.010	0.380	✓			
L	0.525	+/-0.010	0.530	✓			
M	0.13 x 45°	+/-0.030 x 0.5°	0.13 x 45°	✓			
N	R0.50	+/-0.030	0.50	✓			
O	12.76	+/-0.030	12.76	✓			
P	3.38	+/-0.030	3.38	✓			
Q	3.75	+/-0.030	3.75	✓			
R	5.187	+/-0.010	5.186	✓			
S	5.25	+/-0.030	5.250	✓			
T	7.13	+/-0.030	7.13	✓			
U	Ø0.260	+0.006/-0.001	0.260	✓			
V	0.30	+/-0.030	0.310	✓			
W	0.93	+/-0.030	0.926	✓			
X	1.30	+/-0.030	1.290	✓			

Measured by:	JL
Date:	11-11-28

Audited by:	amk
Date:	11/11/28

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.05.01	New Issue	KJ/JLM	
B	08.05.06	Dimension I removed	KJ/DD	

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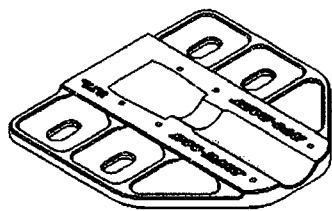
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DESIGN CB		DRAWN BY CB		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED B		APPROVED [Signature]		DRAWING NO. REV. A D3529 SHEET 1 OF 2	
DATE 07.01.04			TITLE SCALE R44 BEARPAW 1:4		
REV A	DATE 07.01.04		DESCRIPTION NEW ISSUE		

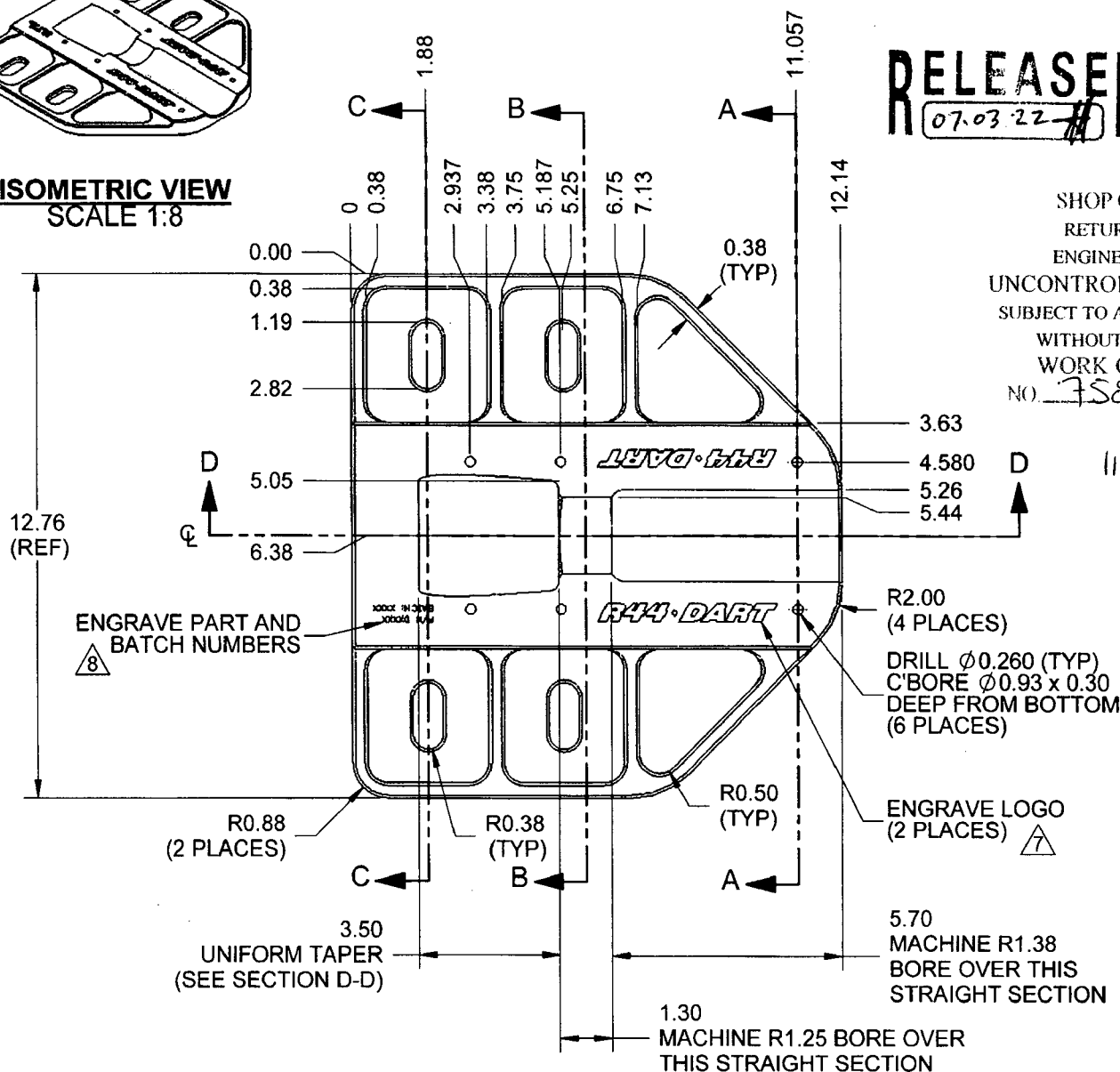


ISOMETRIC VIEW
SCALE 1:8

RELEASED
07.03.22

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 75821

NO. 75821
M.L.J.
D 11/10/3



D3529-1 R44 BEARPAW

NOTES:

- 1) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1.00 THICK (MACHINE TO 0.950)
- 2) FINISH: NONE
- 3) PART IS SYMMETRIC ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) ENGRAVE LOGO TO MAX DEPTH OF 0.012 AT LOCATION SHOWN
- 8) ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010 AT LOCATION SHOWN

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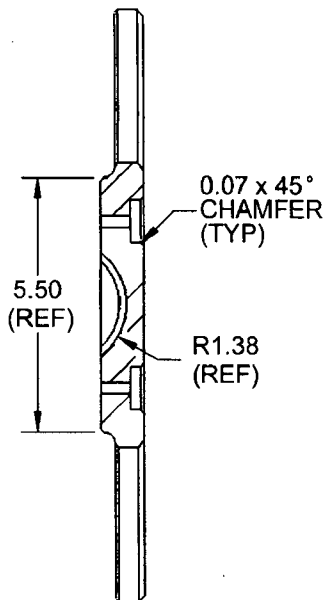
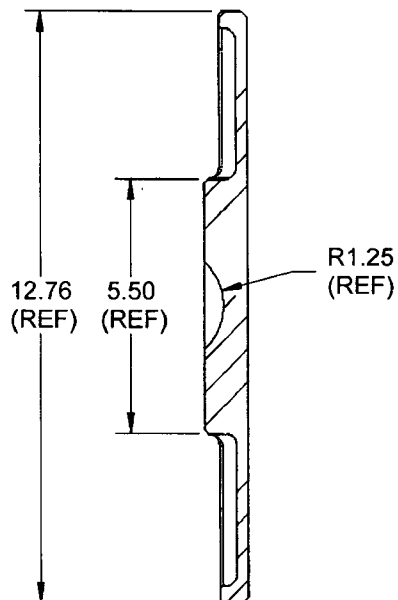
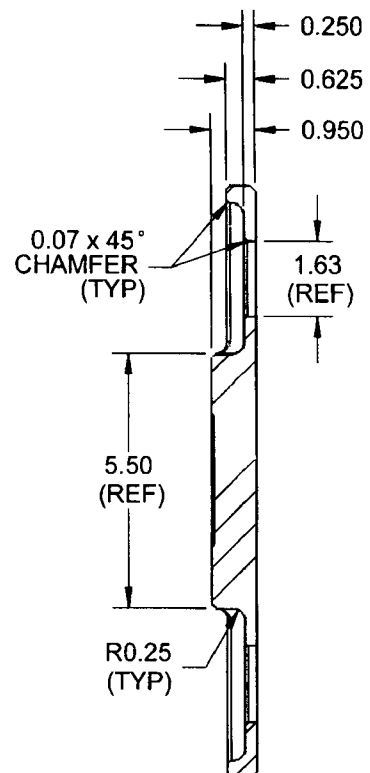
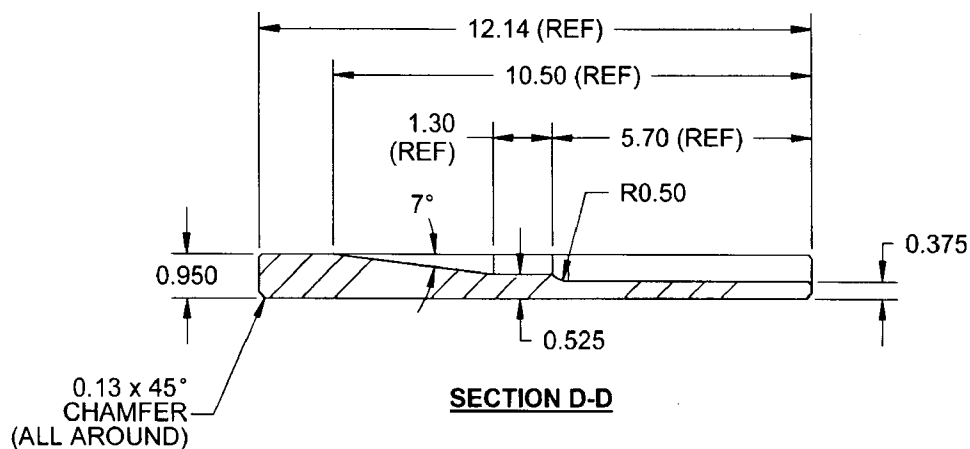
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DART

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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3529	REV. A SHEET 2 OF 2
DATE 07.01.04		TITLE R44 BEARPAW	SCALE 1:4

RELEASED
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